

Date: Thursday, 26/02/2009 11:41:05 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB ASSY (INBOARD)
Job Number : 46090	
Estimate Number : 13661	
P.O. Number :	Part Number : D3827041
This Issue : 26/02/2009 S.O. No. :	Drawing Number : D3827 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 45609	Material :
Written By :	Due Date : 04/03/2009 Qty: 6 [£] Um: Each
Checked & Approved By : <u>JD 09.02.20</u>	
Comment : Est Rev:A 08-12-01 new issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D37591	Bushing
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing

batch: B 45 794 → 12xJD 09/03/11

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 8.4000 f(s)/Unit Total: 33.6000 f(s)

304 SQ Tube .75x.75x.065W

batch: M110839 → 42BM 110969→ 8,400JD 09/03/11

(6x)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 11- cut D3827-1 rib as per dwg D3827 JD2- drill holes using DT9435 jig and open to finish size as per dwg D3827 JD3- c'sink as per dwg JD4- remove identification markings JD5- deburr JDJD 09/03/11

(6x)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEPJD 09/03/11 (6)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1- weld bushing in rib as per dwg D3827

A/R ER316 S.S. Rod Batch: M1108775JD 09/03/11

(6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 26/02/2009 11:41:05 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (INBOARD)

Job Number: 46090

Part Number: D3827041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- grind weld flush

3- deburr if necessary

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09/03/11

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 09-03-11

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *BASKET CELL*

PD 09/03/11

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/12

Job Completion



mf 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

D3827-041 RIB ASSY (INBOARD)

RELEASED
08/11/23

A	NEW ISSUE	MB	08.09.23
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	AD	D3827	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
DATE	08.09.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

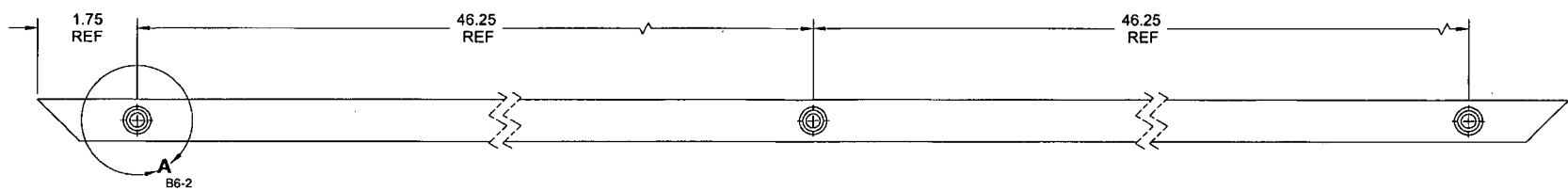
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.59 lbs

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WITHOUT NOTICE
WORK ORDER
NO. 14090

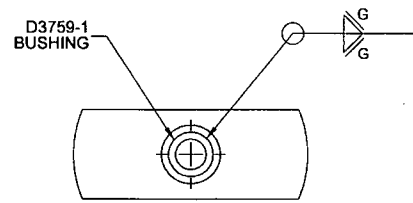
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D3827-041 RIB ASSY (INBOARD)



DETAIL A C7-2
SCALE 2X
3 PL

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RELEASED
08/11/18 VVJ

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D3827	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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8 7 6 5 4 3 2 1

$\phi 0.375^{+0.020}_{-0.000}$ THRU
 $\phi 0.49 \times 100^\circ$ CSINK
 ON BOTH SIDES
 TYP

0.375

46.250

46.250

1.750

0.75 X 45° CHAMFER
 2 PL

0.75
REF

0.065
REF

0.75
REF

96.00

D3827-1 RIB

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 WITHOUT NOTICE
 WORK ORDER
 NO. 1100

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.55 lbs

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08/11/23

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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